

Work Order ID 106605

D 2913
B 106605

106605

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September-10-13 9:19:14 AM

Item ID: D2913

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Doubler

Start Date: 9/10/13

Start Qty: 24.00

24

Cust Item ID:

Required Date: 9/13/13

Req'd Qty: 24.00

24

Customer:

Reference:

Run Start

NR1

Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop

NR2

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D2913

Rev B

0.00

110

110

~~HAAS CNC VERTICAL MACHINING #1~~

0.00

Waterjet

Memo

FLOW CNC Waterjet

cut as and Dwg D2913

PROG FILE: B

DWG REV: 3

DEBURR

0.00

120

120

QC2- Inspect parts off machine FAI/FAIB

0.00

QC

Memo

Quality Control

24 0 Jm.3-12-9

24 0 Jm.3-12-9

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Item ID: D2913 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Doubler
 Start Date: 9/10/13 Start Qty: 24.00 *24* Cust Item ID:
 Required Date: 9/13/13 Req'd Qty: 24.00 *24* Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|----------------------------------------|--------------------------------------------------------------|---------------------------------------|---------|--------|-------------------|---------------|---------------|------------------|-------------------------------|
| 130 *130* QC Quality Control | QC8- Inspect parts - second check Memo | 0.00 DAS 27 9-89 13/12/09 | | | | 24 Cen | | | |
| 140 *140* Small Fab Small Fab | Small Fab Memo 1- Deburr2- C'sink as per Dwg D2913 | 0.00 0.00 | | | | 24 | | | DAS 36 9-89 13/12/09 |
| 150 *150* Brake NC Brake NC | NC BRAKE Memo Bend as per Dwg D2913 | 0.00 0.00 | | | DAS 30 9-89 | 24 | | | 13/12/10 |

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Item ID: D2913 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Doubler
 Start Date: 9/10/13 Start Qty: 24.00 *24* Cust Item ID:
 Required Date: 9/13/13 Req'd Qty: 24.00 *24* Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|----------------------------------------------|-------------------------------------------------------------------------------------------------------------|---------------------------------------|---------|--------|--------------|---------------|---------------|------------------|-------------------|
| 160 *160* QC Quality Control | QC5- Inspect part completeness to step on W/O Memo | 0.00 DAS 27 9-89 13/12/10 | | | | 24 can | | | |
| 170 *170* HandFinish Hand Finishing | Chemical Conversion Coat per QSI005 4.1 Memo | 0.00 0.00 | | | | 24 | 76 | 13-12-11 | |
| 180 *180* Powdercoat Powder Coating | White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum 11/26/804. Memo START TIME: 9:05 FINISH TIME: 9:55 | 0.00 0.00 | | | | 24 | 0 | 13-12-11 | DAS 34 9-89 |

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Item ID: D2913 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Doubler
 Start Date: 9/10/13 Start Qty: 24.00 *24* Cust Item ID:
 Required Date: 9/13/13 Req'd Qty: 24.00 *24* Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|----------------------------------------|---------------------------------------------------------------|---------------------------------------|---------|--------|--------------|-------------------|---------------|------------------|------------------------------------------|
| 190 *190* QC Quality Control | QC3- Inspect Part Finish Memo | 0.00 DAS 27 9-89 13/12/18 | | | | 24 Clerk | | | |
| 200 *200* Packaging Packaging | Identify as per dwg & Stock Location: _____ Memo 57021 | 0.00 0.00 | | | | DAS 32 9-89 | 13/12/18 | (24) | |
| 210 *210* QC Quality Control | QC21- Final Inspection - Work Order Release Memo | 0.00 0.00 | | | | | | | 9/13/18 RM 13/12/18 ME 13-12-18 |

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Required Qty: 24.00

Comments: IPP: C00.06.22Removed P/O for powder coatEC

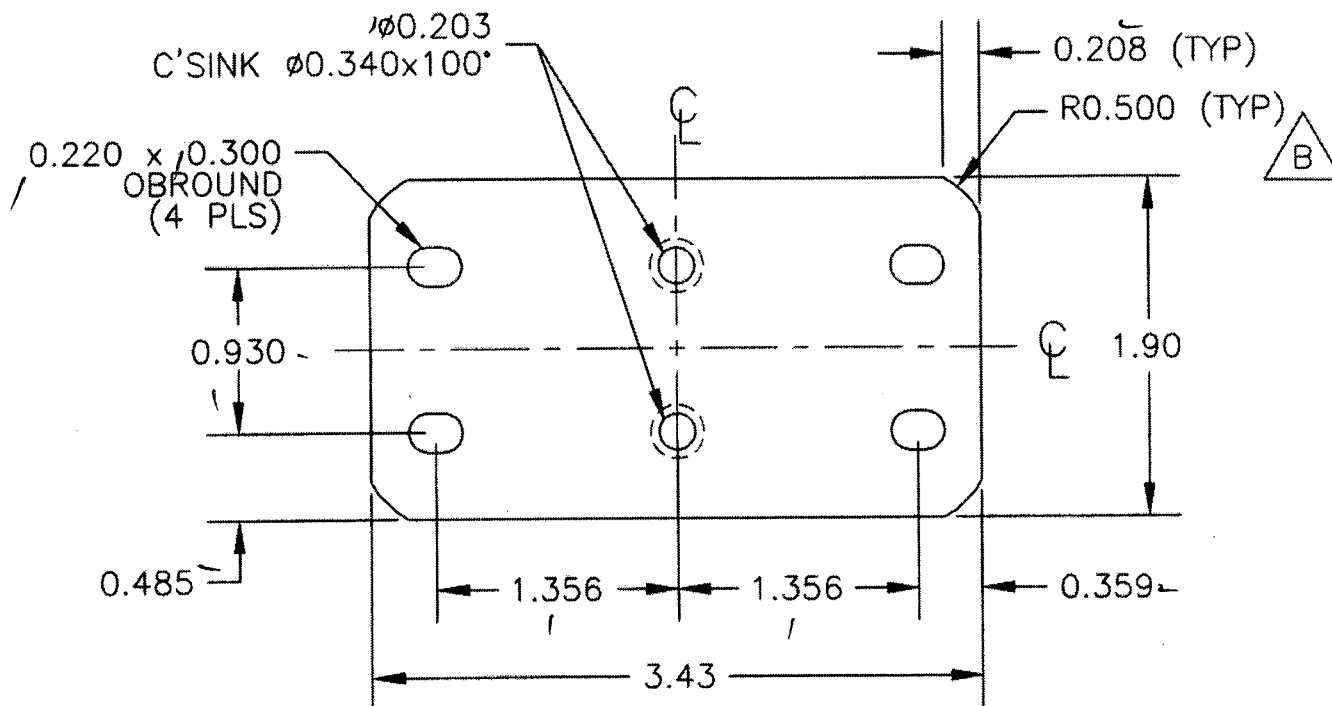
[illegible]



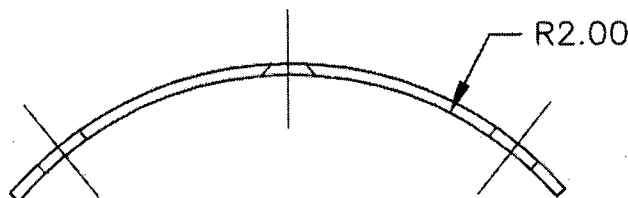
| | | | |
|------------------|------------------|---------------------------------------------------|------------------------|
| DESIGN | DRAWN BY RT | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| CHECKED CP | APPROVED | DRAWING NO. D2913 | REV. 8 SHEET 1 OF 1 |
| DATE 99.10.18 | TITLE DOUBLER | | SCALE 1:1 |
| A | 99.10.07 | NEW ISSUE | |
| B | 99.10.18 | ADDED RADIUS | |

RELEASED
19.10.19 DS

FLAT PATTERN



BEND DETAIL



MATERIAL: 2024-T3 (QQ-A-250/4) OR 6061-T6 (QQ-A-250/11)
0.080 THICK
FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1
POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
BREAK ALL SHARP EDGES 0.010 TO 0.020